



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W23-13
Job Sheet 185001



Part No: RBE105-31702W23-13

Job Qty: 2 ea

Part Name: Measuring Flange Plate LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W23 Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-2		31.1.1. AS 19-01-02
110	Mori Seiki	2 pcs	11/30/18	11/30/18	0.00	4.00	MORI NV5000-2		AS 19-12-29 19-01-02
120	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-4		AS 19-12-29 19-01-02
130	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-4		B. 19-01-10 19-01-02
140	Outsource	2 pcs	11/30/18	11/30/18	0.00	0.00	Outsource1 (Atlantic)		CC 19-01-10
150	Packaging	2 pcs	11/30/18	11/30/18	0.00	0.00	Packaging2		JAN 18 2019
190	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC6		36
200	Packaging	2 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		Dart
210	QC21-SA	2 Ea	11/30/18	11/30/18	0.00	0.00	QC21		3-88 JAN 22 2019

Part Op 110 - ***Cut blanks to 2.17*** 1-Machine as per folio FC 484 FOLIO REV: A1 DWG REV: 1
Descriptions: 2-Deburr Atlantic
140 - 1-Issue P/O to METCORE; P/O RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type;
4140 4- Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.500X2.250	MT-4140-B-1.500 X 2.250 W	.3620 (.181 ea)	90-Start up Operation	5055878

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-1.500X2.250	0	0	0

Part Specifications

could not be found.



Container No: S141421



Part: RBE105-31702W23-13

Job No: 185001

Serial No/Batch: S141421

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/03/19

Plex 10/19/18 2:38 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

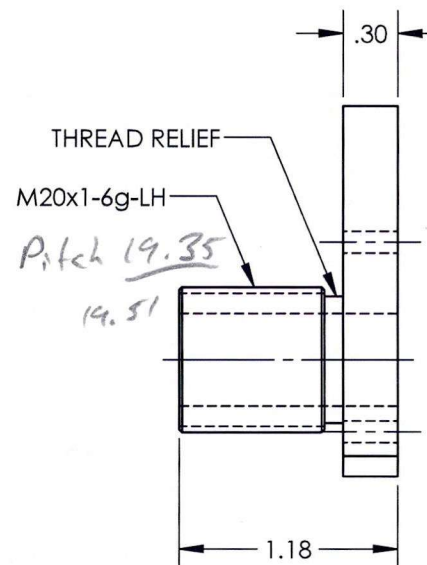
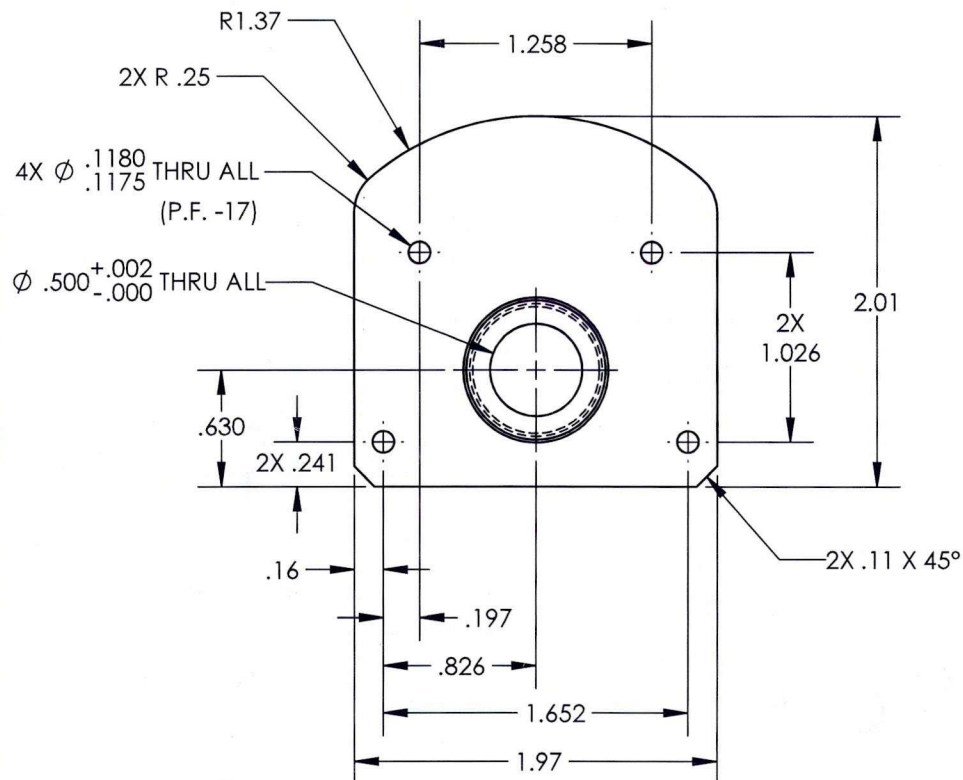
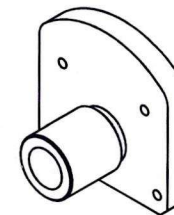
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SUPER COPY
 RETURN TO
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 185001 M.5
 18-10-19

(13)

MEASURING FLANGE PLATE LH

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W23-13	REV 1
MAT'L 4140/4142 HEAT RC 40-45 FINISH SEE -9 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 1/18/2016 SHEET 8 OF 9



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042231



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

PO No: PO042231
PO Date: 1/10/19
Due Date: 1/17/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184033	C3-12-3	Lock - C3 Hook 1--Issue P/O to Atlantic; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Atlantic to ship directly to Groupe Altech***	Firmed	-	1/17/19	10 pcs	0 pcs	10 pcs	\$17.00/pcs	\$170.00
2	187978	RBE105- 31702W23- 11	Measuring Flange Plate RH 1--Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	1 pcs	0 pcs	1 pcs	\$170.00/pcs	\$170.00
3	185001	RBE105- 31702W23- 13	Measuring Flange Plate LH 1--Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	4 pcs	0 pcs	4 pcs	\$42.50/pcs	\$170.00

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Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER PO042231



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	188092	RBE105-31702W23-13	Measuring Flange Plate LH 1-Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	4 pcs	0 pcs	4 pcs	\$42.50/pcs	\$170.00
5	185002	RBE105-31702W23-11	Measuring Flange Plate RH 1-Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	7 pcs	0 pcs	7 pcs	\$24.285714/pcs	\$170.00
Grand Total:											\$850.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/15/19 3:29 PM dart.tsimiklis.chrisoula

Shipping Ticket

Sold To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

1448

HAWKESBURY ON K6A 1K7

Ship To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

159112

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
042231				

Quantity	Part No. / Part Name / Part Description	Pounds
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4 PCS MATERIAL 4140

ANNEAL THEN HEAT TREAT TO 40 - 45RC

C OF C , BEAD BLAST (DO NOT BLAST THREADS) PART # RBE105-31702W23-13, JOB # 1

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

4

Pounds Shipped:

2.00

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Order No.: 162057

Shipped Complete

Quantity Shipped:

4.00

Received By:

Date:

Pounds Shipped:

2.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 01/11/2019

AF
41 Rc
1-17-19

Certification

Date: 01/17/2019

Entry Date: 01/11/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: 042231

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
4	4 PCS MATERIAL 4140 ANNEAL THEN HEAT TREAT TO 40 - 45RC C OF C , BEAD BLAST (DO NOT BLAST THREADS) PART # RBE105-31702W23-13, JOB # 185001	2

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

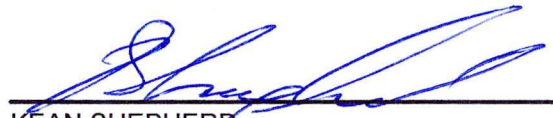
Results:

Harden ROCKWE	40.	45.	41.	TESTED AS PER SAMPLING PLAN
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HEAT TREATED TO 41 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

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KÉAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD